

Date: Wednesday, 23/07/2008 3:03:02 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 40733	Part Number	: D2888
Estimate Number	: 11683	Drawing Number	: D2888 REV A2
P.O. Number	:	Project Number	: N/A
This Issue	: 23/07/2008 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: 1/1 Type : MACHINED PARTS	Due Date	: 12/08/2008
Previous Run	: 37167	Qty:	10 Um: Each
Written By	:		
Checked & Approved By	: <u>JLD 08.7.23</u>		
Comment	: Est. C 00.06.22 Removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2500X03500	6061-T6 Bar 2.50 x 3.50
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3.05



*Only 32 inches left
 of M105212



Comment: Qty.: 0.3938 f(s)/Unit Total: 3.9375 f(s)

6061-T6 Bar 2.5" x 3.5"

Material: 3.5" x 2.5" bar 6061-T6

Batch M105212

SA 08/08/01

(11)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks 4.20" long

(Grain along 4.20")

SA 08/08/01 (10)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2888

Deburr and Tumble

DIP 08/08/02/ SA

PTO →

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/08/05

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 08/08/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2888 PAR #: N/A Fault Category: Prod/Production NCR: Yes No DQA: D Date: 08/08/07
 QA: N/C Closed: D Date: 08/08/08

NCR: <u>40733</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/03	3.0	First part Scrap due to wrong origine on last operation bc operator took wrong origine	<i>[Signature]</i>	change the origine Scrap and Destroy and Replac. Qty <u>(4)</u> B# 105212	<i>[Signature]</i> 08/08/03	<i>[Signature]</i> 08/08/05	<i>[Signature]</i>	<i>[Signature]</i> 08/08/05

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Drawing Name: LUG

Job Number: 40733

Part Number: D2888

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/08/06

(10)

7.0

POWDER COATING

POWDER COATING



M108523



(10X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:15
320°F
2:45

M-1

08/08/06

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

08/08/06

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 970

08/08/07

(10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/07

MF 08-08-07

Job Completion



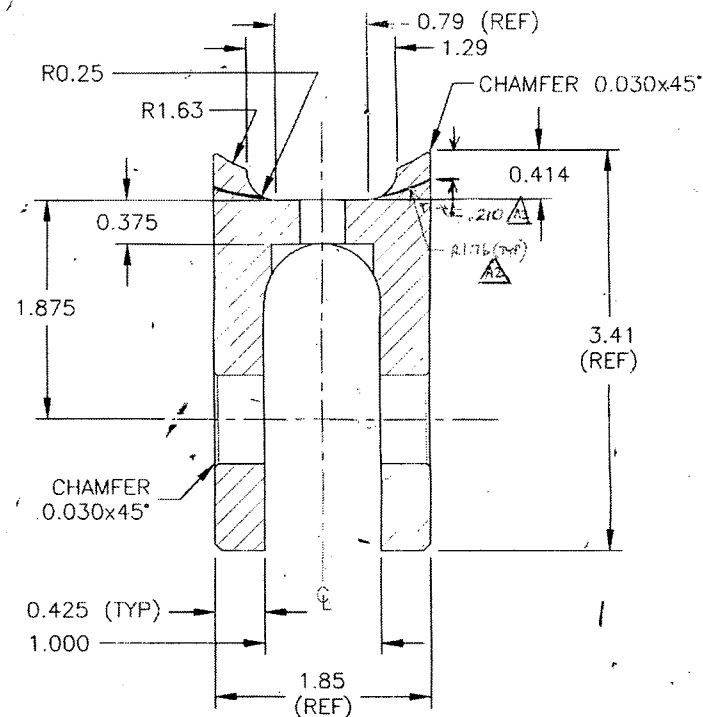
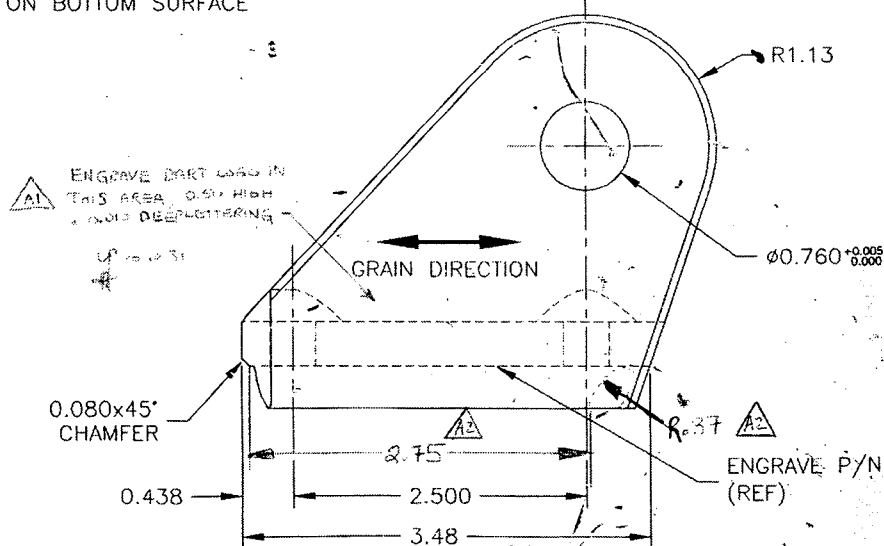
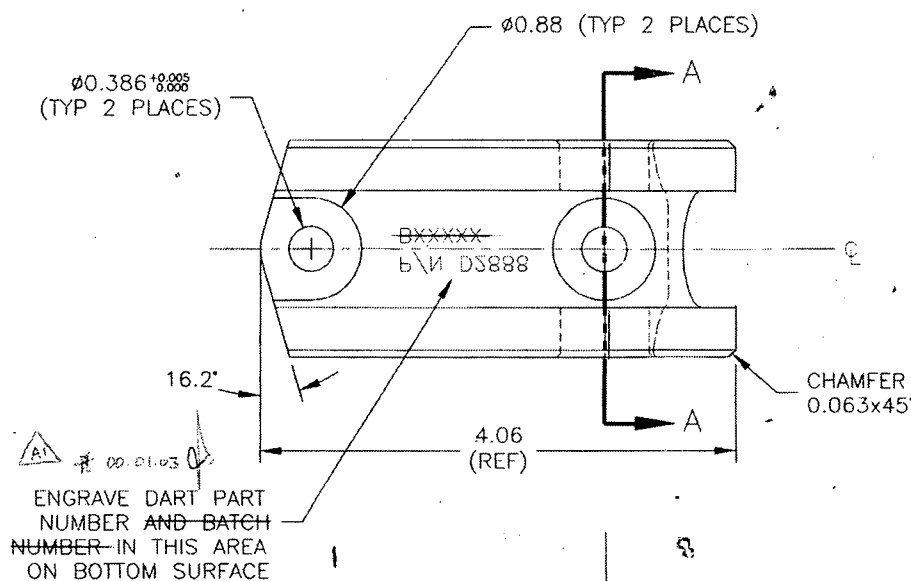
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION A-A
SCALE 1:1

RELEASED
99.07.01 DS

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BREAK UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A	99.06.21	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2888
DATE	99.06.21	TITLE LUG

A2	04.04.08	Add Saddle Clearance for NCR 784
A1	01.10.31	Update Engineering

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WITHOUT NOTICE
WORK ORDER
NO. 40735

DART AEROSPACE LTD		Work Order: 40733
Description: Towing Lug		Part Number: D2888
Inspection Dwg:	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R1.13	± 0.030	1.130	✓			
Ø0.760	$+0.005/-0.000$	0.762	✓			
R0.37	± 0.030	0.370	✓			
3.48	± 0.030	3.480	✓			
2.500	± 0.010	2.503	✓			
2.75	± 0.030	2.749	✓			
0.438	± 0.010	0.436	✓			
0.080 x 45°	$\pm 0.010 / \pm 1/2^\circ$	0.080 x 45°	✓			
4.06 (REF)	± 0.030	4.057	✓			
16.2°	$\pm 1/2^\circ$	16.2°	✓			
0.063 x 45°	$\pm 0.010 / \pm 1/2^\circ$	0.055 x 45°	✓			
Ø0.88		0.877	✓			
Ø0.386	$+0.005/-0.000$	0.389	✓			
0.79 (REF)	± 0.030	0.790	✓			
1.29	± 0.030	1.290	✓			
R0.25	± 0.030	0.250	✓			
R1.63	± 0.030	1.630	✓			
0.030 x 45°	$\pm 0.010 / \pm 1/2^\circ$	0.030 x 45°	✓			
0.210	± 0.010	0.207	✓			
0.414	± 0.010	0.414	✓			
0.375	± 0.010	0.375	✓			
1.875	± 0.010	1.870	✓			
3.41 (REF)	± 0.030	3.415	✓			

Measured by: DJP	Audited by: J.L.	Prototype Approval:
Date: 08/08/03	Date: 08/08/06	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

